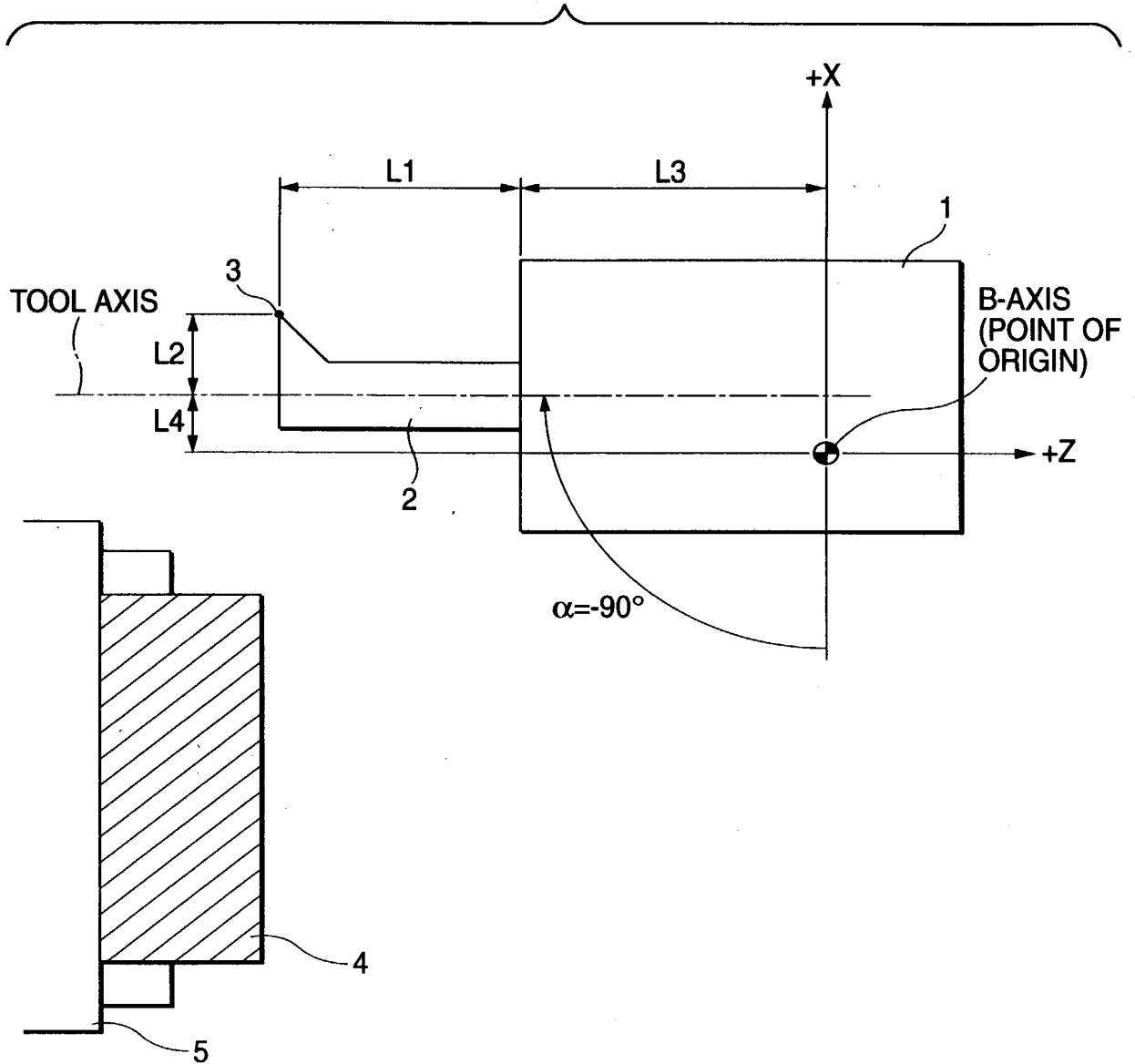


FIG. 1



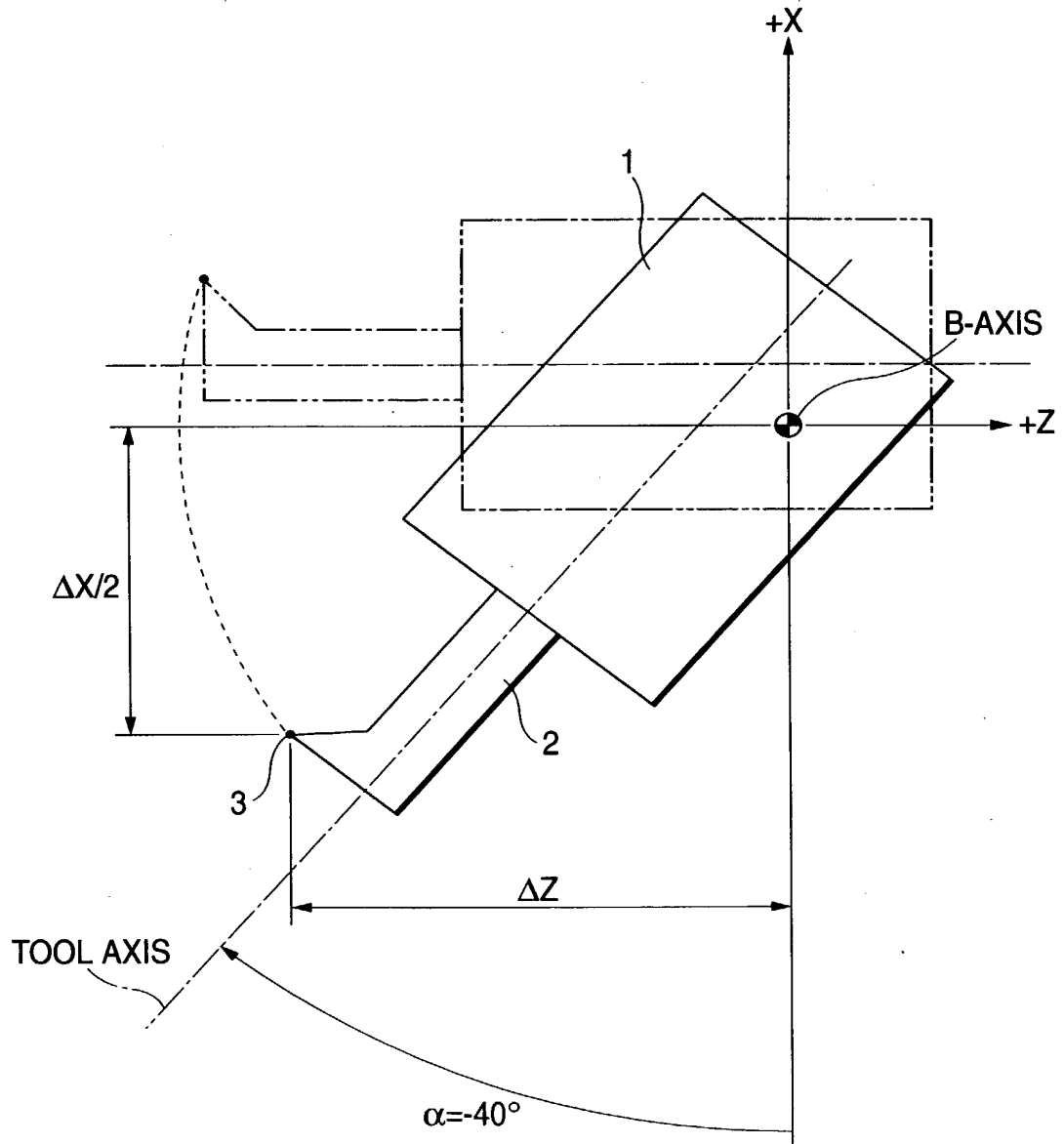


FIG. 3

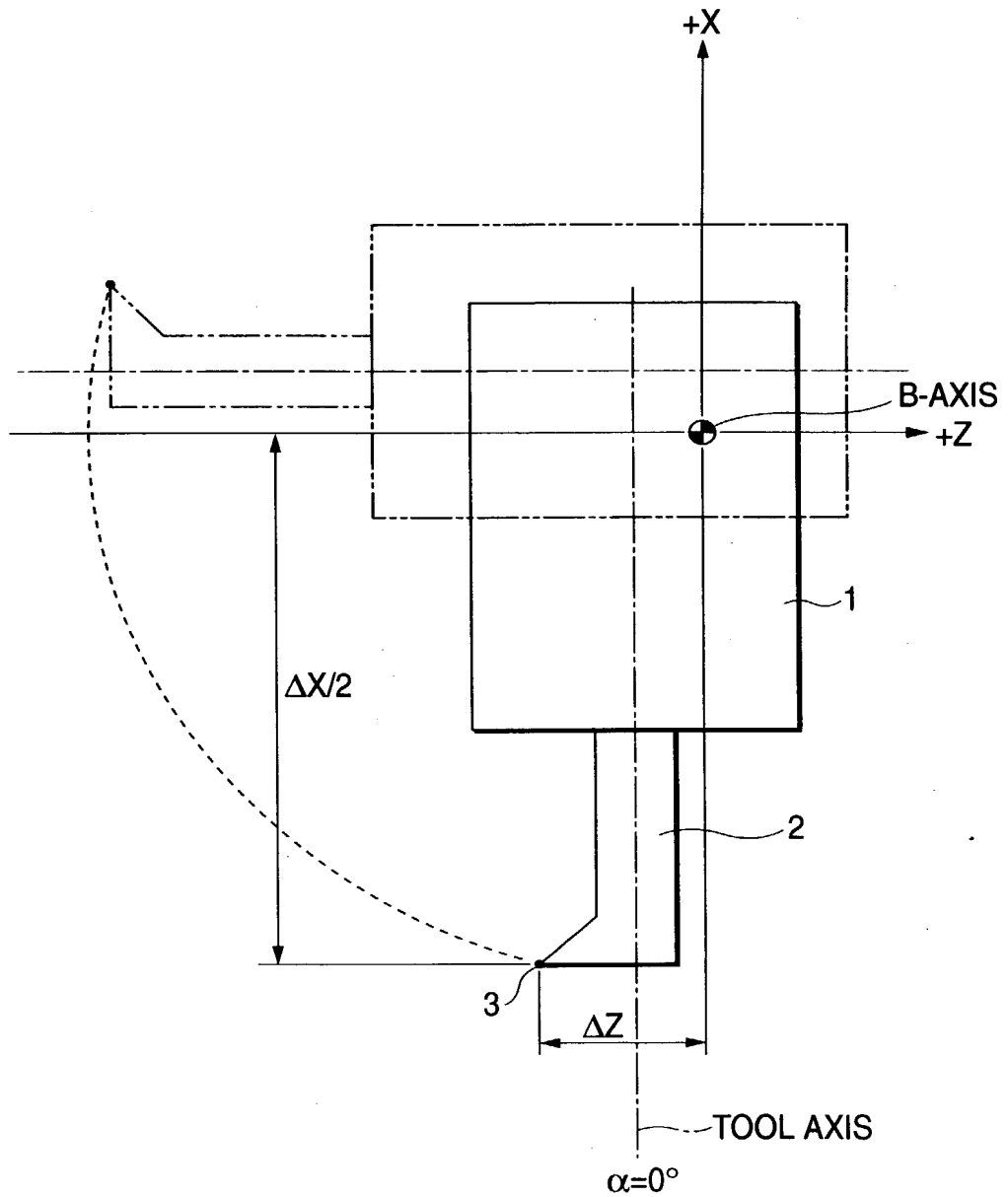
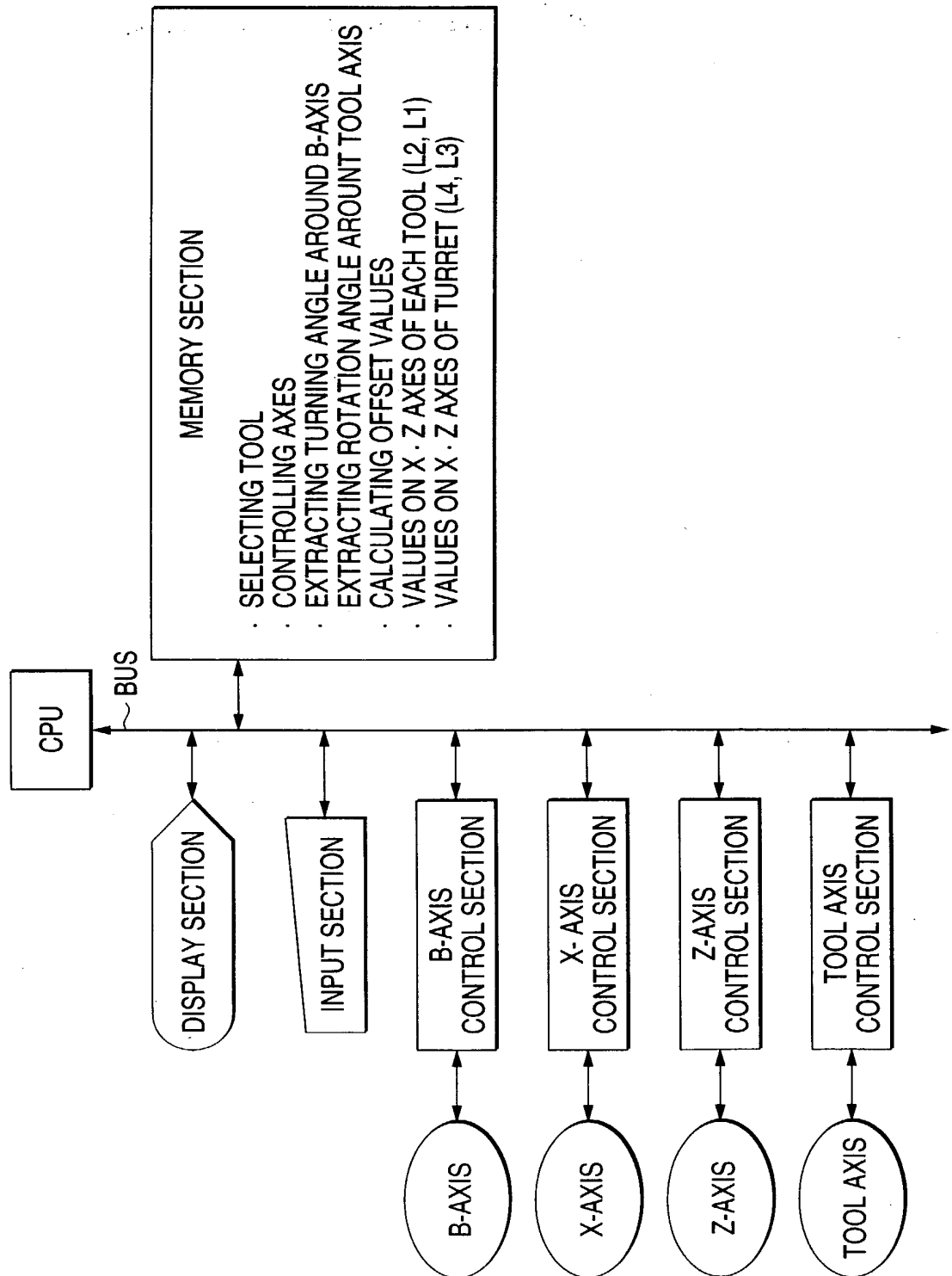


FIG. 4



TOOL	TURNING ANGLE	OFFSET ON X AXIS ( $\Delta X$ )	OFFSET ON Z AXIS ( $\Delta Z$ )	
TURNING	-90.0° (INITIAL POSITION)	-22.00 ( $\Delta X_0$ )	400.00 ( $\Delta Z_0$ )	
	-40.0°	598.69	265.54	
(WEAR COMPENSATION VALUE)		$\Delta X_t$	$\Delta Z_t$	
		-0.09	-0.04	
		-0.24	-0.09	
		-0.29	-0.14	

TURNING	0.0°	800.00	11.00	

FIG. 5

FIG. 6

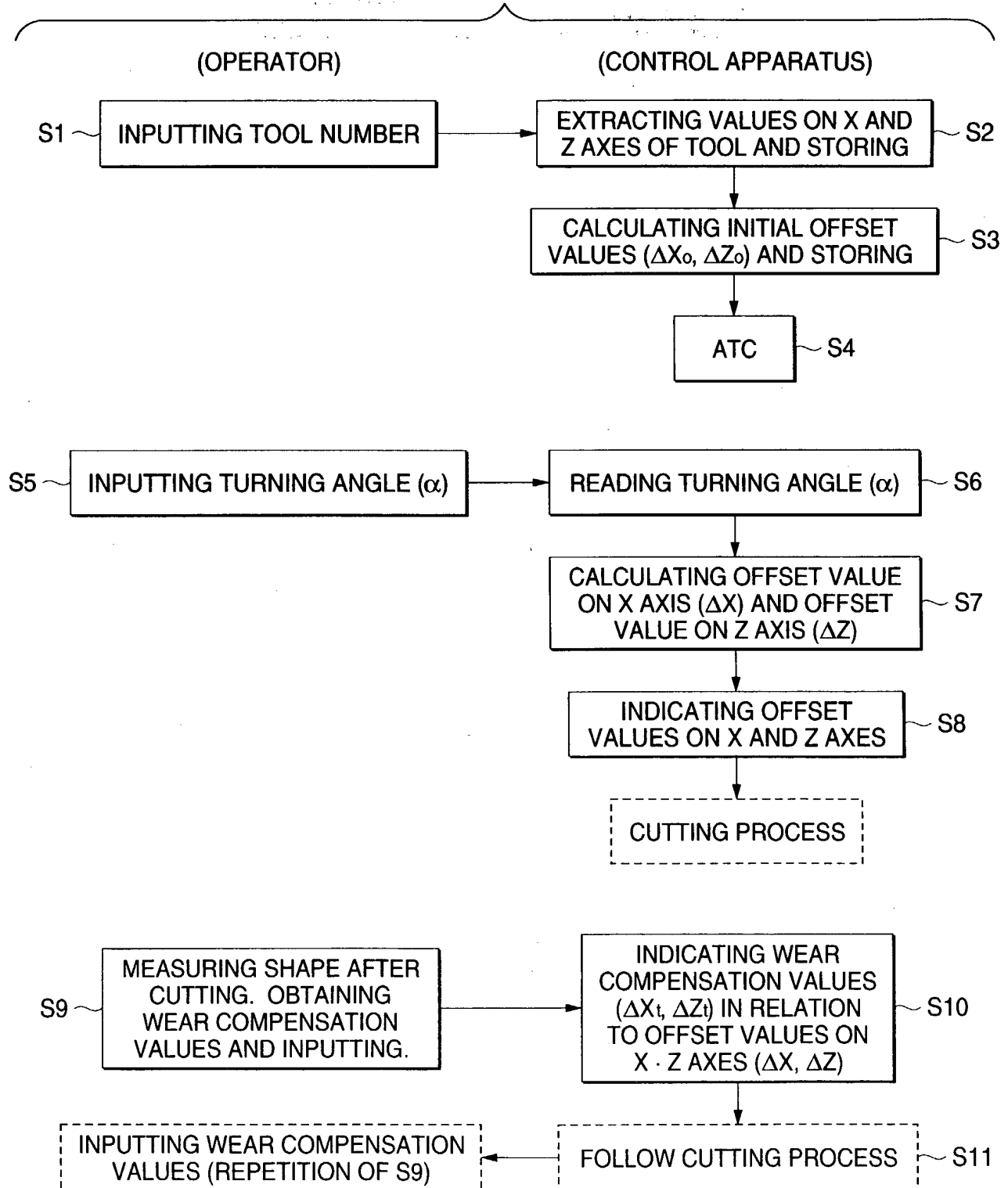
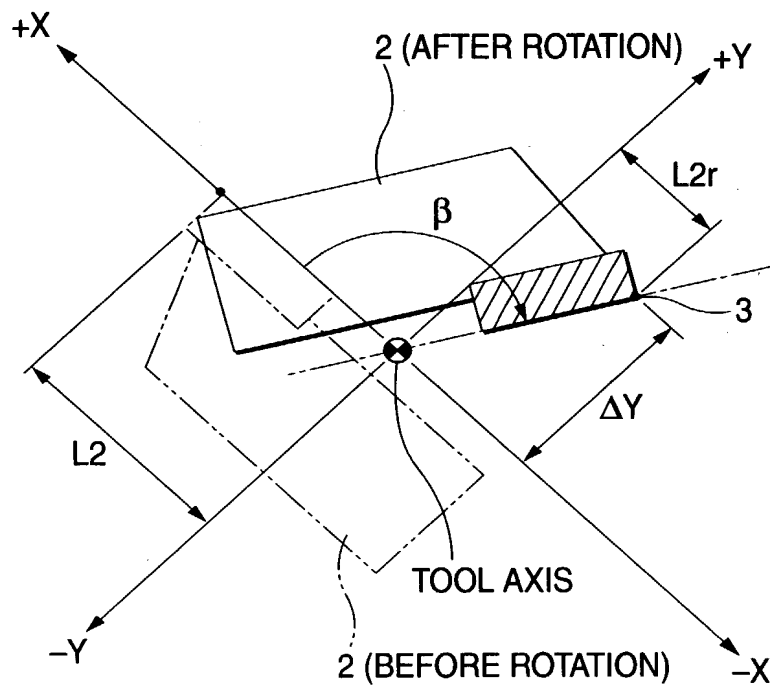


FIG. 7



**FIG. 8**





FIG. 9

TOOL	TURNING ANGLE ( $\alpha$ )	ROTATION ANGLE ( $\beta$ )	OFFSET ON X AXIS ( $\Delta X$ )	OFFSET ON Z AXIS ( $\Delta Z$ )	OFFSET ON Y AXIS ( $\Delta Y$ )
TURNING	-90.0° (INITIAL POSITION)	0.0°	-22.00 ( $\Delta X_0$ )	400.00 ( $\Delta Z_0$ )	0.00 ( $\Delta Y_0$ )
	-40.0°	0.0°	598.69	265.54	0.00
	-40.0°	120.0°	617.98 ( $\Delta X_t$ )	254.05 ( $\Delta Z_t$ )	-8.66
	(WEAR COMPENSATION VALUE)		$\Delta X_t$	$\Delta Z_t$	$\Delta Y_t$
			-0.08	-0.05	-0.06
			-0.13	-0.10	-0.10